

Date: Tuesday, 27/01/2009 11:11:46 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PANEL
Job Number : 45278	
Estimate Number : 10906	
P.O. Number :	Part Number : D33303
This Issue : 27/01/2009 S.O. No. :	Drawing Number : D3330 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : D
Previous Run : 44308	Material :
Written By :	Due Date : 05/02/2009 Qty: 4 Um: Each
Checked & Approved By : <u>JNO 29.01.27</u>	
Comment : Est. A05.01.13 New issue KJ/JLM Est Rev:B Now on Waterjet 06-09-25 JLM est C 07.05.14 rev C dwg ec Est D 07.12.12 Rev D dwg EC verified by:DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S125	1010-1025 sheet .125
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Comment: Qty.: 0.7130 sf(s)/Unit Total : 2.8518 sf(s)
 1010-1025 sheet .125
 Batch: 109447 B 9-2-3

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3330
 Dwg Rev: D
 Prog Rev: D

B 9-2-3

(8)

2-Deburr if necessary B 9-2-3

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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B 9-2-3



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S 01/02/03 (78)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: _____

9/2/4 (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 27/01/2009 11:11:46 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL

Job Number: 45278

Part Number: D33303

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/04 JJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mk 09-02-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 45278
Description: Plate		Part Number: D3330-3
Inspection Dwg: D3330	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.250	+0.005/-0.001	.251	X			
1.02	+/-0.030	1.024	X			
2.500	+/-0.010	2.504	X			
7.00	+/-0.030	6.997	X			
3.26	+/-0.030	3.261	X			
6.05	+/-0.030	6.052	X			
7.11	+/-0.030	7.110	X			
R0.125	+/-0.010	.125	X			
13.98	+/-0.030	13.94	X			
0.852	+/-0.010	.852	X			
1.505	+/-0.010	1.502	X			
4.653	+/-0.010	4.658	X			
1.250	+/-0.010	1.251	X			
0.10	+/-0.030	.103	X			

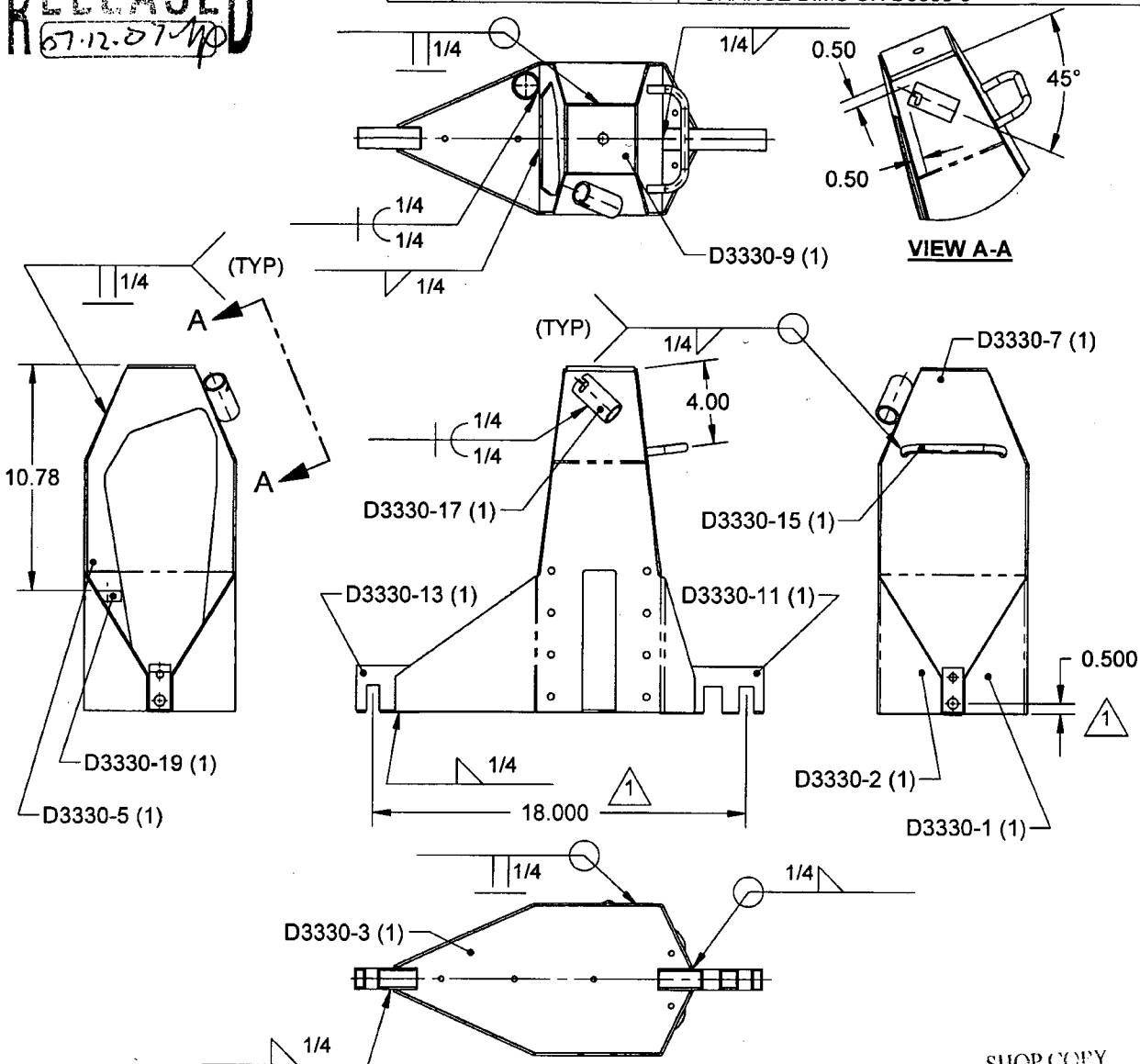
Measured by: RB	Audited by: S	Prototype Approval: N/A
Date: 9-2-3	Date: 07/02/03	Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.05.16	New Issue	KJ/JLM	B



DESIGN 13	DRAWN BY DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 13	APPROVED [Signature]	DRAWING NO. D3330	REV. D SHEET 1 OF 9
DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:8
REV	DATE	DESCRIPTION	
A	04.12.16	NEW ISSUE	
B	05.02.26	RE-DESIGN	
C	07.03.20	ADD 0.100 DIM; RAISED BEND OF -1/2 BY 0.125	
D	07.12.06	CHANGE DIMS ON D3330-9	

RELEASED
07.12.07



D3330-041 FRAME WELDMENT

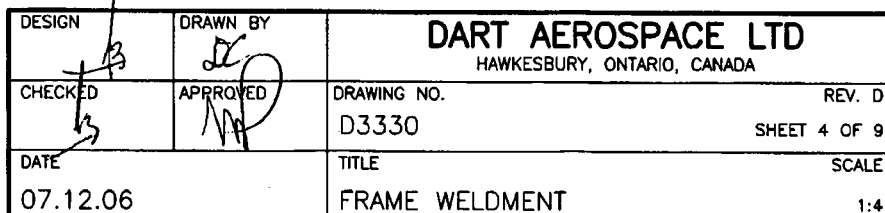
NOTES:

- 1) POSITION PARTS AS PER JIG D3330-041T1
- 2) WELD PER QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

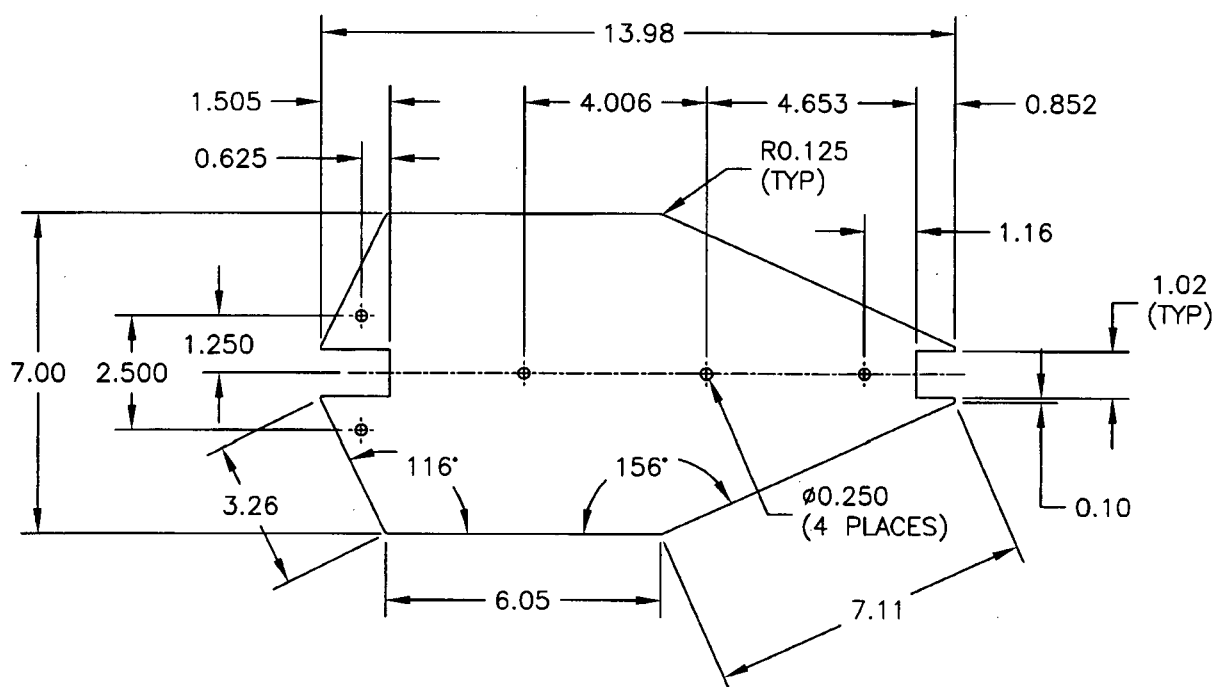
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RELEASED
07-12-07



D3330-3 PLATE

1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21 ~~ECT TO AGREEMENT~~
38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK) ~~POINT NO. 1~~
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

NO 45278

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